

Work Order ID 133665

Tuesday, June 16, 2015 9:18:25 AM

133665

Page 1

Item ID: PB67-43001-203

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Square Tube

Stop ***NS2***

Start Date: 6/16/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: JUN 16 2015

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001

D

100

Weld per dwg A/R Aluminum rod Batch: 130855

Small Fab

100

Large Fab

Large Fab

Memo

0.00

- 1- Cut to length as per dwg
- 2- Drill holes as per dwg use DT10030
- 3- Make a chamfer on both side of the 2 holes as per dwg
- 4- Deburr

5- Grind weld flush as per dwg.

JUL 16 2015

DAS
24
9-89

4X

DL 15/6/30

110

QC10- Inspect visual per QSI004- ground welds

0.00

110

QC

Quality Control

Memo

0.00

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Picklist Print

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Page 1

Work Order ID: 133665

133665

Parent Item: PB67-43001-203

PB67-43001-203

Parent Item Name: Square Tube

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec IPP Rev B
10.10.05 per RevC EC verified by DD IPP Rev:C 14.12.16 DWG
REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6TS1.000W.12
0

Purchased

No

f

42.0000

(7)

M6061T6TS1 000W 120

6061T6 SQ TUBE 1.00 x 1.00 X .120w

125

m 132577

**

7.5

DL 15/6/30

Location

Loc Qty

Loc Code

MAT051

42

m126686

42

PB67-43001-227RevB1

Manufactured

No

140

Each

0.0000

2

8

**

JUL 16 2015

DAS
24
9-89

PR67-43001-227RevB1

Bushing

B 43712 → 4

B 112760 → 4

DQA: _____ Date: _____



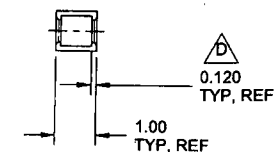
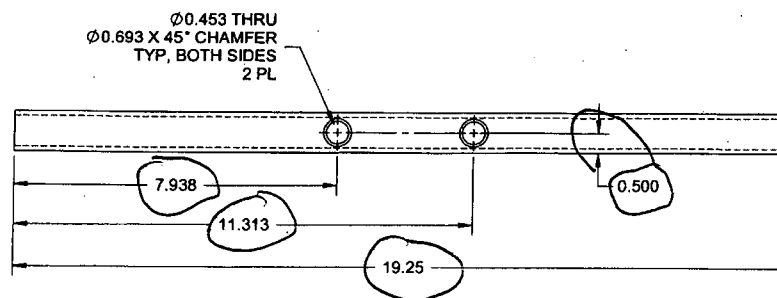
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

ITEM	QTY -203W	P/N	DESCRIPTION
	X	B67-43001-203W	SQUARE TUBE WELDMENT
1	1	B67-43001-203	SQUARE TUBE
2	2	B67-43001-227	BUSHING

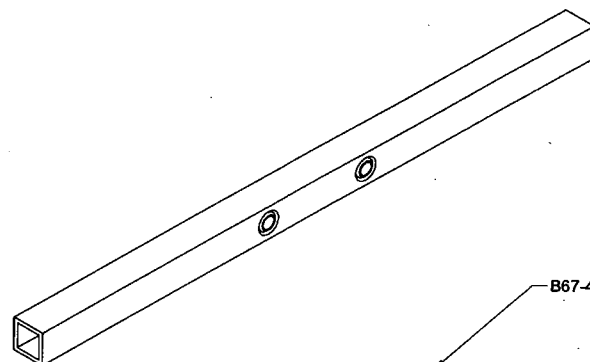


B67-43001-203 SQUARE TUBE

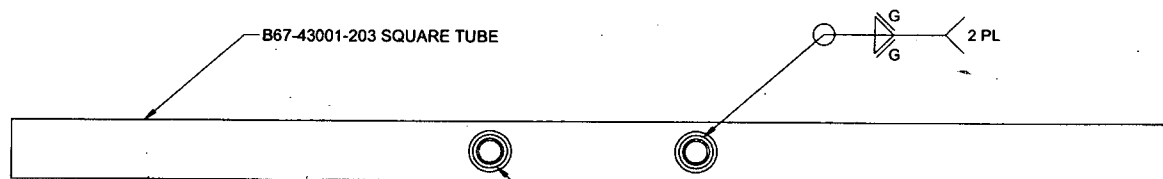
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 133665 MLW
1506-16

RELEASED
2014-12-08



B67-43001-203 SQUARE TUBE



B67-43001-227 BUSHING
2 PL

B67-43001-203W SQUARE TUBE WELDMENT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6TS1.000W0.120
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.81 lbs
- 8) WELDING: PER DART QSI 004

D	0.120 WALL THICKNESS WAS 0.065, ADD NOTE 8 (WELDING), ADD -203W WELDMENT REASON: FACILITATE MANUFACTURING	DB	14.07.21
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#08-011.	MB	09.02.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	DB		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	14.07.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-203** REV. D
SHEET 1 OF 1
TITLE **SQUARE TUBE** SCALE NTS

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